Work Order ID 52855

Left hand

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start**

Revision ID: M **Stop**

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

09-10-15

Run Start

Approvals: **Process Plan:** _____ **Date:** ~~10-09~~ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile & type labels per PPP D206-642-251		CHG001						

Draw Nbr	Revision Nbr
D3804	A
IIN-D206-642	M

N/A

LEFT

Work Order ID 52855

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 9-10-19

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.
Pick:
Qty ☐Part Number☐ Description☐Batch
A/R☐☐ Aluminum Rod☐ m10243/m11999 BE 9-10-20 BE 9-10-20

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025. AWM 9-10-21

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time. M 9-10-23

Work Order ID 52855

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. 12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804 13-Remove D3286-1 doubers, identify orientation, deburr, then attach them to the workorder 14-Remove indexing edge using DT8741 as per Dwg D3804 15-C'sink GHW rivet holes as per Dwg D3804								
120 QC Quality Control	QC6- Inspect dimensions to drawing **Memo**	0.00 0.00							

11-9-10-23

2) 8 on 10/23

(40) 6

Work Order ID 52855

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00				1		M 9-10-23	
Skidtubes	**Memo**	0.00							
Skidtubes	1-Open crossbolt holes to Ø0.3125" 2- Open Aft cap hole #6. ****no wearplate holes for this skidtube**** 3-Deburr tube and blow out chips from inside the tube								
140	Chemical Conversion Coat per QSI005 4.1	0.00				1		M 9-10-23	
HandFinish	**Memo**	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00 2) ∫ 09/10/23				(1)			
QC	**Memo**	0.00							
Quality Control									

Work Order ID 52855

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
Skidtubes	Skidtubes					1	0	9-10-23	
Skidtubes	**Memo**	0.00							
	1-Open holes to finished size as per Dwg D3804, (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) 3-Deburr and blow out all chips from inside the tube								
170	QC6- Inspect dimensions to drawing	0.00							
QC		0.00							
Quality Control	**Memo**								

Work Order ID 52855

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00				1	9/10/26		PTO →
Skidtubes	**Memo**	0.00							
Skidtubes	1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting Start Date:☐ 9/10/26 ☐Time:☐ 9:20 ☐ Finish Date:☐ 9/10/27 ☐Time:☐ 9:20 AM Pick: Qty ☐Part Number☐Description☐Batch A/R☐☐Sikaflex-291☐ M11239 ☐ Sikaflex expire date:☐ 10/2/30								
190	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

→ 9/10/27

Dart Aerospace Ltd

W/O: 52855		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE** Perm. Chang	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
9/10/23	# 180	-Stock web (D2654-3) Doesn't have extra holes Per Run on wear Plates To be Drilled by hand after installing. -Re dimDim Per QS7005	M 9/10/26	N/A ↓ NCR			09/10/23

Part No: D206-642-251 **PAR #:** _____ **Fault Category:** Skid tubes **NCR:** Yes (No) See W/O 52858 **DQA:** _____ **Date:** 05.11.25

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
9/10/23	# 180	Stock webs missing holes for wear plates #2 not Drilled on w/o 48679 # missed @ inspection	QSI042	-Drill holes in web per Dwg in correct Location - Re dimDim Per QS7005	M 9/10/23	09/10/23	QSI042	09/10/23
		R.C: LOA.	QSI042	recorded on W/O 52858 w/ same issue			QSI042	

NOTE: Date & initial all entries

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**
Revision ID: M
Item Name: Replacement Skidtube
Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**
Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**
Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
Skidtubes	Skidtubes								
Skidtubes		0.00							

Memo

1-remove alodine from around hole and prepare for welding BC 09/10/27

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
Pick:
Qty☐Part Number☐Description☐Batch
A/R☐☐Aluminum Rod☐ M112507 BC 09/10/27 AWM 9-10-28

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.
A/R☐SS Rod☐ NONE BC 09/10/28

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr — AWM 9-10-28

Work Order ID 52855

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start**

Revision ID: M **Stop**

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 HandFinish Hand Finishing	HandFinishing	0.00							
	Memo Install D2680-041 Nut Plate as per Dwg D3804	0.00							
220 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							
230 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							

9-10-29

QC10 Sep/10/29

QC9 PD 09.10.29

⇒ Sep/10/29

Work Order ID 52855

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 **Memo**	0.00 0.00	MD 09/11/02			X1			
250 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 112148 **Memo** START TIME: 3:20 OVEN TEMPERATURE: ~~320°~~ FINISH TIME: ~~3:50~~	0.00 0.00	BL 09-11-2		1				
260 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00	MD 09/11/05			X1			

Work Order ID 52855

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	HandFinishing	0.00				X1			
HandFinish	**Memo**	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.					MD 09/11/05			
280	HandFinishing	0.00				X1			
HandFinish	**Memo**	0.00							
Hand Finishing	1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R□□Sikaflex-291□ M11 2391 Sikaflex expire date:□ 10/20					MD 09/11/05			
	2-Wing Walk as per Dwg D3804 and QSI 005 4.4□ Batch: M11 2/06								

Work Order ID 52855

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start**

Revision ID: M **Stop**

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
300	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
310	Packaging	0.00							
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-251 Location: PPP-52820 PPP Rev:								

Work Order ID 52855

October 15, 2009 2:46:35 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
320	QC21- Final Inspection - Work Order Release	0.00					09/11/06		
QC	**Memo**	0.00							
Quality Control									

MF
09-11-05

Picklist Print

October 15, 2009 2:46:40 PM

11

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2620RevB Skidtube, 206 Skidtube		Manufactured	No			110	Each	19.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	19	
45898	19	

9-10-19

D3286-1RevA Doubler		Manufactured	No			110	Each	27.0000	2.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	27	
44286	1	
46440	6	
47692	20	

9-10-22

D2647RevF Cap		Manufactured	No			110	Each	27.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	27	
10773	7	
43846	20	

BE 09/10/20

Picklist Print

October 15, 2009 2:46:40 PM

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3212-4-04		Purchased	No			180	Each	704.0000	52.0000			
Cherry Rivet												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	704			
109297	26			
109740	16			
110153	6			
111127	78			
112314	378		58	H 9/10/26
112612	200			

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2654-3RevE1		Manufactured	No			180	Each	10.0000	1.0000			
Web												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	10			
48679	10		1	H 9/10/26

Picklist Print

October 15, 2009 2:46:40 PM

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			200	Each	617.0000	20.0000			
Cross Bolt Spacer												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
LG	83			
51529	83			
Main Warehouse				
ST	534			
36013	5			
47112	383			
48271	146		20	BE 09/10/27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3286-3RevA		Manufactured	No			200	Each	43.0000	2.0000			
Spacer												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	43			
35048	1			
41900	1			
43862	1			
46643	40		2	BE 09/10/28

Picklist Print

October 15, 2009 2:46:40 PM

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CCR264SS3-3		Purchased	No			210	Each	267.0000	2.0000			
Cherry Rivet												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	267	
111548	52	
111827	115	
112314	100	

9-10-29

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3212-4-03		Purchased	No			210	Each	310.0000	2.0000			
Cherry Rivet												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	310	
111359	96	
112314	200	
15984	14	

M110139

9-10-29

Picklist Print

October 15, 2009 2:46:40 PM

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2680-041RevB1		Manufactured	No			210	Each	79.0000	1.0000			
Nut Plate												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	79	
33061	14	
44086	65	

9-10-29

D3805-043RevA		Manufactured	No	52843		270	Each	0.0000	1.0000	X1	MD	09/11/05
Wearplate Assembly Fwd, HighGear												
D3805-047RevA		Manufactured	No	52842		270	Each	0.0000	1.0000	X1	MD	09/11/05
Wearplate Assembly Aft, High Gear												
AN3-37A		Purchased	No			270	Each	773.0000	7.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	773	
105425	273	
111668	500	

X7 MD 09/11/05

Picklist Print

October 15, 2009 2:46:40 PM

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L		Purchased	No			270	Each	4,446.000	7.0000			
washer												

Warehouse Location	Loc Qty	Loc Code
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	4346	
112116	993	
112612	3353	

XT MO 09/11/05

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			270	Each	3,503.000	7.0000			
Nut												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	3503	
110844	32	
111274	41	
111668	930	
112314	2000	
112385	500	

XT MO 09/11/05

Picklist Print

October 15, 2009 2:46:40 PM

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3873-1RevA		Manufactured	No			270	Each	73.0000	14.0000			
Bushing												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse	53443		X14 mo 09/11/05
ST	28		
46757	6		
48267	22		
Main Warehouse			
ST139	45		
50479	45		

AN960JD10L		Purchased	No			270	Each	5,969.000	2.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	5969		
101291	16		
104885	153		
105793	236		
109632	564		X2 mo 09/11/05
110985	5000		

Picklist Print

October 15, 2009 2:46:40 PM

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-08		Purchased	No			270	Each	3,035.000	2.0000			
Screw												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	3035	
110467	192	
110552	843	
110835	2000	

X2 mo 9/11/05

D2651-1RevB		Manufactured	No			270	Each	403.0000	8.0000			
Plug												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	403	
43990	125	
45490	28	
51530	250	

X8 mo 9/11/05

Picklist Print

October 15, 2009 2:46:40 PM

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-3RevB		Manufactured	No			270	Each	1,035.000	8.0000			
O-Ring												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1035	
43849	3	
46114	1032	

X8 mo 09/11/05

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-4-06		Purchased	No			270	Each	77.0000	1.0000			
Screw												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	77	
109061	77	

X1 mo 09/11/05

Picklist Print

October 15, 2009 2:46:40 PM

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			270	Each	5,441.000	1.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	5441		
102929	2		
105906	4		
106277	2		
107321	23		
107939	114		
108161	521	XL	MO 09111105
108827	31		
109249	69		
110523	340		
111279	101		
111916	482		
112314	3752		
16941	0		

Picklist Print

October 15, 2009 2:46:40 PM

Work Order ID: 52855

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2646RevC		Manufactured	No			280	Each	53.0000	1.0000			
Aft Cap												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	53	
20208	0	
43801	1	
~~46327~~	4	
48109	48	

~~X1~~ MD 03/11/05

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

1) MATERIAL: N/A
2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 -POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
7) IDENTIFICATION: NONE
8) WEIGHT: 12.5 lb
9) WELD PER DART QSI 004
10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
 THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

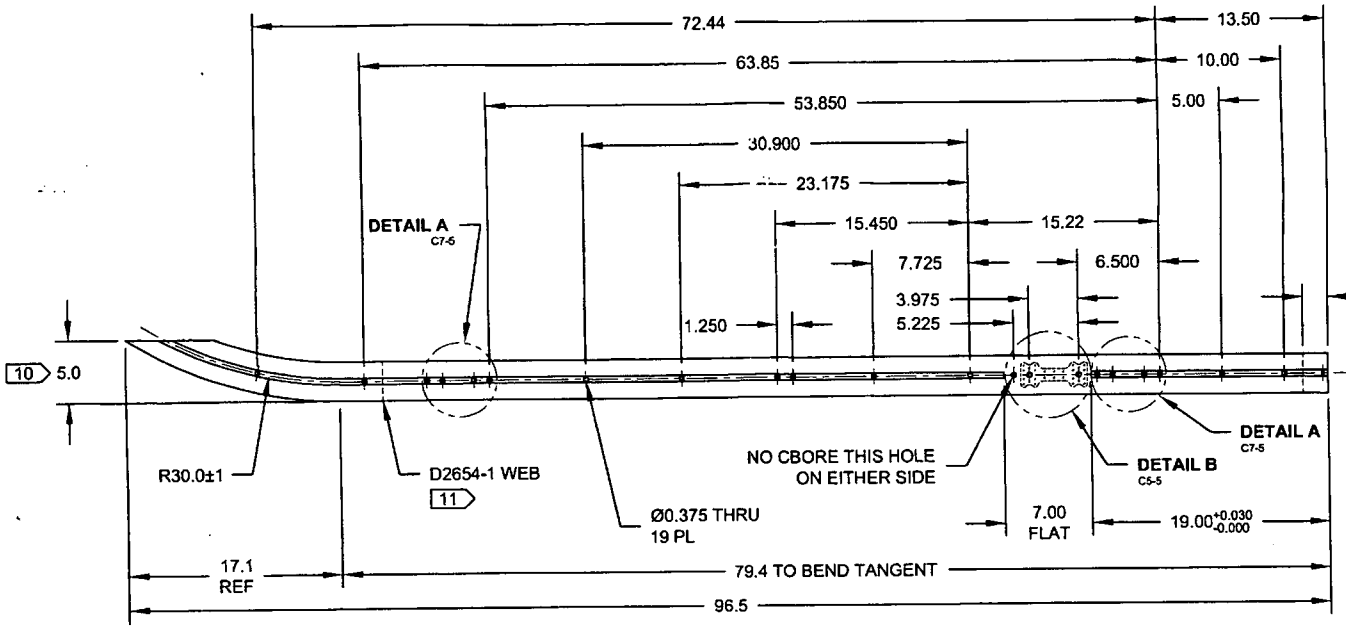
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52855
09-10-15

RELEASED
09.03.09
per ECN 09-536

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	08.07.07

DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3804	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07		

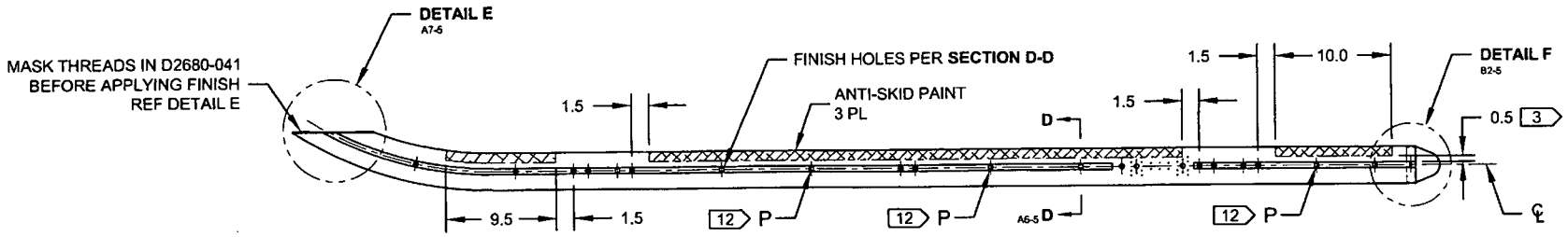
COPYRIGHT © 2008 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



D3804-041 BENDING/DRILLING DETAIL

RELEASED
09.03.07

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52555

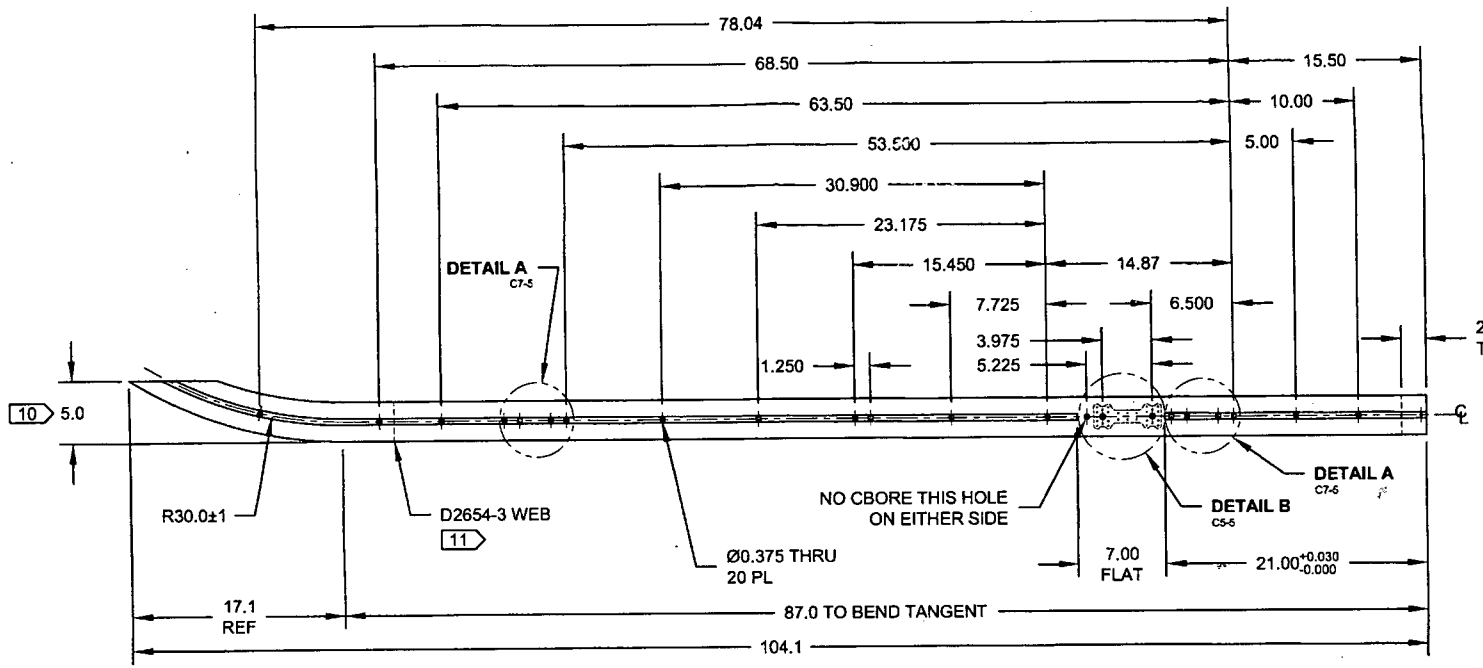


D3804-041 ASSEMBLY/FINISHING DETAIL

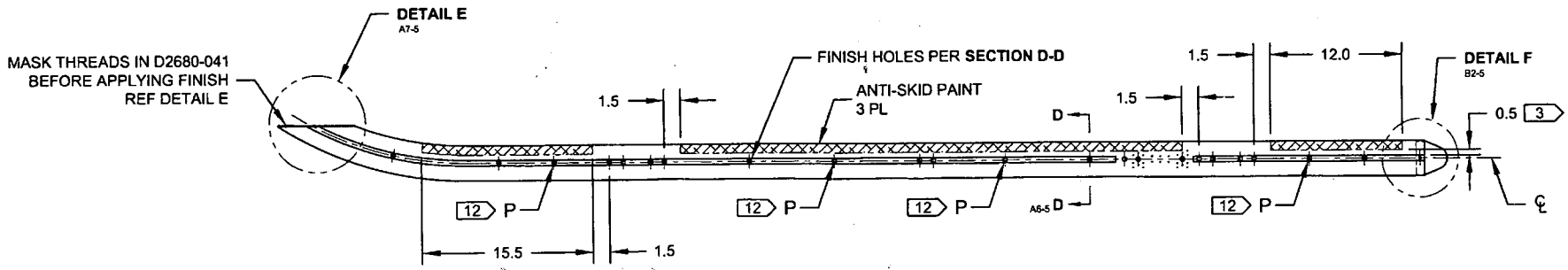
DESIGN		**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D3804 — REV. A — SHEET 2 OF 5
MFG. APPR.		
APPROVED		TITLE: SKIDTUBE ASSEMBLY, 206A/B — SCALE: NTS
DE APPR.		
DATE 08.07.07		

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED
09.03.07



D3804-043 BENDING/DRILLING DETAIL



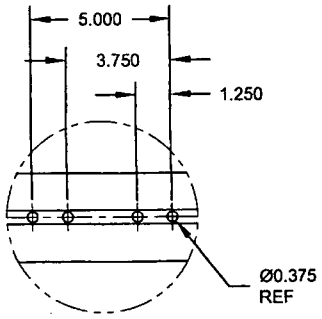
D3804-043 ASSEMBLY/FINISHING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 528559

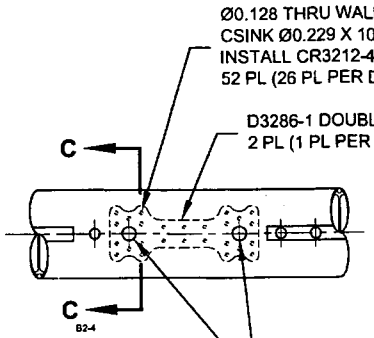
DESIGN		DART AEROSPACE USA, INC
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3804 SHEET 3 OF 5
APPROVED		TITLE SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B NTS
DATE	08.07.07	

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED
09.03.07

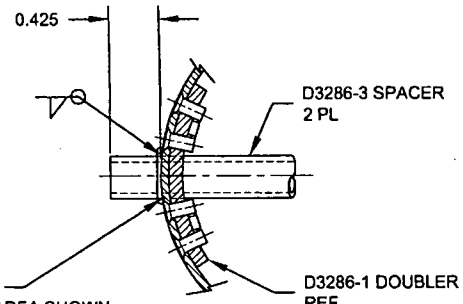


DETAIL A D6-2 C2-2 D6-3 C2-3
SCALE NONE



ENLARGE TO Ø0.500 IN D3286-1
ENLARGE TO Ø0.625 IN TUBE
4 PL (2 PL PER SIDE)

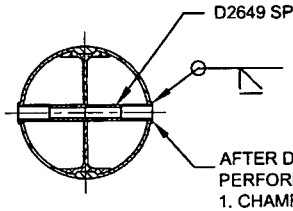
DETAIL B C3-2 C3-3
SCALE NONE



TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52855



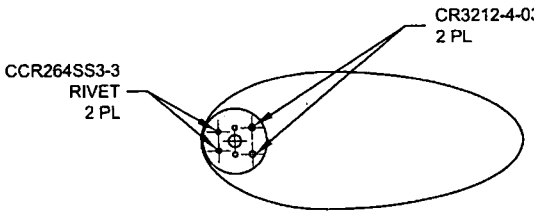
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2 A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

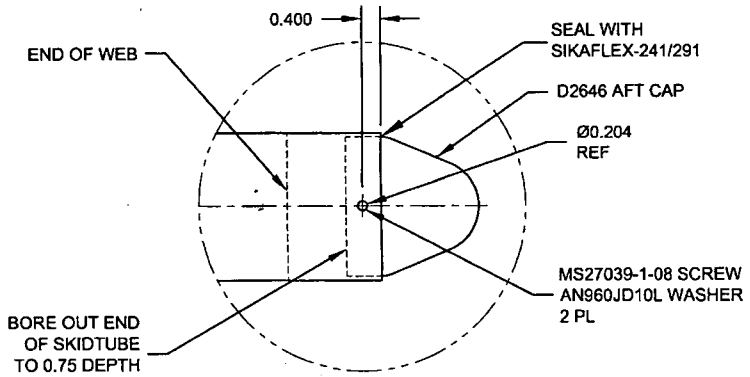
DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3804	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07		

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

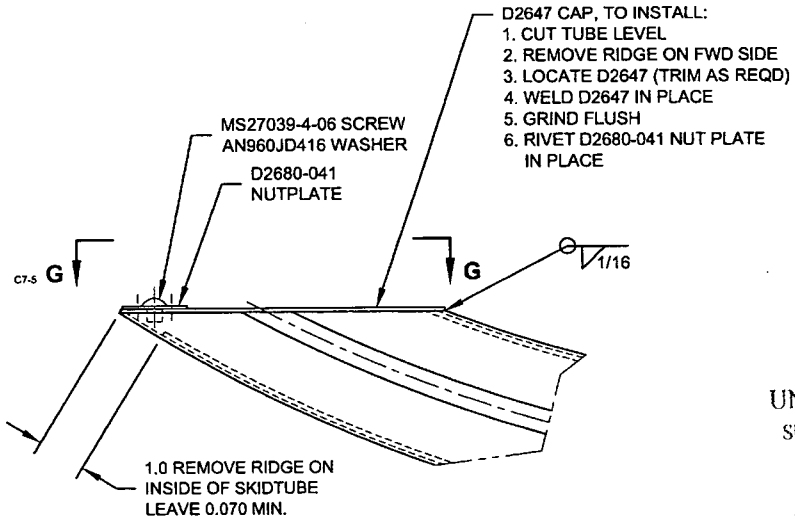
RELEASED
9 09.03.07



VIEW G-G
SCALE NONE A7-5



DETAIL F
SCALE NONE B2-2 B2-3



DETAIL E
SCALE NONE B7-2 B7-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52855

DESIGN		**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D3804 — REV. A — SHEET 5 OF 5
MFG. APPR.		
APPROVED		TITLE: SKIDTUBE ASSEMBLY, 206A/B — SCALE: NTS
DE APPR.		
DATE 08.07.07		

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

NO. 214

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52855
Part number: D206-442-251
Description: 206 skid tube
Welding Process: Tig[✓] Mig[]
Base materiel: Aluminium
Current: AC[✓] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓] fail[]
Penetration:	pass[✓] fail[]

UNACCEPTABLE

Cracks:	pass[✓] fail[]
Undercut:	pass[✓] fail[]
Pin holes:	pass[✓] fail[]
Overlap (cold lap)	pass[] fail[]
Porosity (surface):	pass[✓] fail[]
Coloration:	pass[✓] fail[]

Qualifier Rob Dunn **Date of Test Coupon** 09.10.29

Welder Barclay Elliott **Date of Test Coupon** 09.10.29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld